

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006531**Date Inspected:** 16-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #10 South and North Tower Shop

South Tower Lift #3:- Caltrans QA inspector performed final dry MT inspection on the CJP weld # SSD1-FESA3-1B/C-55~59 A/B of skin plate C for south tower lift #3. All CJP weld for MT inspection have been accepted by ZPMC and ABF QC prior Caltrans QA inspection. Base on Caltrans inspection, the fillet welds on the connection plates appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents. This inspection for green tag release is not include the last 500mm length of diagonal stiffeners near 3. 125m diaphragm section for skin plate B to C and C to D.

North Tower Lift #3:- Caltrans QA inspector performed final dry MT inspection on the CJP weld # NSD1-FESA3-1A/D-7A/B of skin plate E for north tower lift #3. The CJP weld for MT inspection has been accepted by ZPMC and ABF QC prior Caltrans QA inspection. Base on Caltrans inspection, the fillet welds on the connection plates appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Bay #11 East and West Tower Shop

East Tower Lift#3:- Caltrans QA Inspector observed two welders performed SMAW tack welding on four

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

stiffeners to skin plate D of east tower lift #3. The four stiffeners has been re-welded prior installation due to the exceed length has been found by Caltrans QA Inspector few day ago. The four stiffeners number is ESD1-FDSA3-2B/C-56 A/B, 54 A/B, 52 A/B and 50 A/B. Base on Caltrans observation, no discrepancies were noted.

East Tower Lift#2:- Caltrans QA Inspector observed three welders performed fit up and SMAW tack welding on the triangle plate that connected to double diaphragms and skin plates. The triangle plates located at 53m, 65m and 77m of skin plate D and E. The minimum preheat and maximum interpass temperature requirements for SMAW tack welds are 110C degree and 230 C degree. The SMAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West Tower Lift#1:- Caltrans QA Inspector observed five ZPMC workers performed grinding process on the root pass of interior diaphragms. The root pass of interior diaphragms located at elevation from 9m to 47.6m of skin plate A. The grinding process is removing the weld profiles prior VT and MT inspection. Base on Caltrans observation, no discrepancies were noted.

East Tower lift #1:- Caltrans QA inspector performed final VT and dry MT inspection on the PJP and CJP welds of corner diagonal stiffener that connected skin plate C to D and B to C. The corner diagonal stiffener plates are located at elevation 9m to 47.6m diaphragm section of east tower lift #1. All the PJP and CJP welds have been inspected and accepted by ZPMC and ABF QC prior Caltrans QA inspection. Base on Caltrans inspection, the PJP and CJP welds on the corner diagonal stiffener plates appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted within the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

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| Inspected By: | Pau,Wai | Quality Assurance Inspector |
| Reviewed By: | Clifford,William | QA Reviewer |
